









Work Order ID 53021

October 22, 2009 9:44:36 AM

Page 1


Item ID: D3514-047 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Top Mounted Housing Assembly
Start Date: 21/10/2009 Start Qty: 6.00  Cust Item ID:
Required Date: 30/10/2009 Req'd Qty: 6.00  Customer:
Reference:


Approvals: Process Plan:  Date: 09-10-22 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____


Run Start 
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3514	Rev A

100	Small Fab	0.00							
	Small Fab	0.00							
	Memo								
	Assemble as per dwg D3514								

110	QC5- Inspect part completeness to step on W/O	0.00							
	QC	0.00							
	Memo								
	Quality Control								

120	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
	Powdercoat	0.00							
	Powder Coating								
	Memo								
	START TIME: 6:45AM								
	7:15AM								
	FINISH TIME: 320°F								

09/12/03 (5)

=> 09/12/03

=> 09/12/04

(X5)






(X5)



Work Order ID 53021




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Page 2

Item ID: D3514-047 Accept  Setup Start 
Revision ID: A Stop 
Item Name: Top Mounted Housing Assembly
Start Date: 21/10/2009 Start Qty: 6.00  Cust Item ID:
Required Date: 30/10/2009 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
140  Small Fab Small Fab	Small Fab Memo Assemble trim as per dwg D3514	0.00 0.00							
150  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

MD 09/12/04

X5

9/30/12/07 (5)

=> 8 Oct 12 07

(5) f

Work Order ID 53021

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Page 3

Item ID: D3514-047
Revision ID: A
Item Name: Top Mounted Housing Assembly
Start Date: 21/10/2009 Start Qty: 6.00
Required Date: 30/10/2009 Req'd Qty: 6.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Identify as per dwg & Stock Location: <u>233</u>	0.00							
Packaging Packaging	Memo	0.00							
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

09/12/08 (5)

09/12/08

MF
09-12-08

Picklist Print

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Page 1

Work Order ID: 53021

Parent Item: D3514-047RevA

Parent Item Name: Top Mounted Housing Assembly



Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 6.00




Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3514-3RevA		Manufactured	No			100	Each	4.0000	6.0000			
												
Box Top (Top Mounted)												

Warehouse
Location
Main Warehouse
ST179
52286

Loc Qty
4
4



Loc Code
5 3478

D3514-7RevA		Manufactured	No			100	Each	0.0000	6.0000			
												
Box Bottom (Top Mounted)												
D3514-9RevA		Manufactured	No			100	Each	15.0000	6.0000			
												
Hood												

Warehouse
Location
Main Warehouse
ST104
50241

Loc Qty
15
15

Loc Code
5

D3524-041RevA		Manufactured	No			100	Each	5.0000	6.0000			
												
Upper Plate Assembly												

Warehouse
Location
Main Warehouse
ST
34824
53482

Loc Qty
5
5

Loc Code
4

Ep09/12/03

Ep09/12/03

Ep09/12/03

Ep09/12/03

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Work Order ID: 53021



Parent Item: D3514-047RevA



Parent Item Name: Top Mounted Housing Assembly

Start Date: 21/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3526-1RevA		Manufactured	No			100	Each	5.0000	6.0000			
Rubber Seal												

ES09/12/07
B53479 (42)

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1	
35377	1	
Main Warehouse		
ST110	4	
50249	4	

MS20426AD3-3

Purchased

No

100

Each

6,851.000 48.0000



Rivet

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	6851	
1563	0	
19099	4776	
7681	2075	

ES09/12/03
40

Picklist Print

Page 3

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Work Order ID: 53021

Parent Item: D3514-047RevA

Parent Item Name: Top Mounted Housing Assembly




Start Date: 21/10/2009

Required Date: 30/10/2009

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20426AD4-4 		Purchased	No			100	Each	3,208.000	66.0000		<i>Ep 09/12/03</i>	
Rivet												
				<u>Warehouse</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				<u>Location</u>								
				Main Warehouse								
				ST				3208				
					15541			3208			<u>55</u>	
MS20426AD4-9 		Purchased	No			100	Each	1,143.000	24.0000		<i>Ep 09/12/03</i>	
RIVET												
				<u>Warehouse</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				<u>Location</u>								
				Main Warehouse								
				ST				1143				
					18136			1143			<u>20</u>	
MS21072L06 		Purchased	No			150	Each	28.0000	24.0000		<i>Ep 09/12/03</i>	
ANCHOR NUT												
				<u>Warehouse</u>				<u>Loc Qty</u>		<u>Loc Code</u>		
				<u>Location</u>								
				Main Warehouse								
				ST				28				
					101760			8				
					112794			20			<u>17</u>	
											<u>34</u>	
	</											

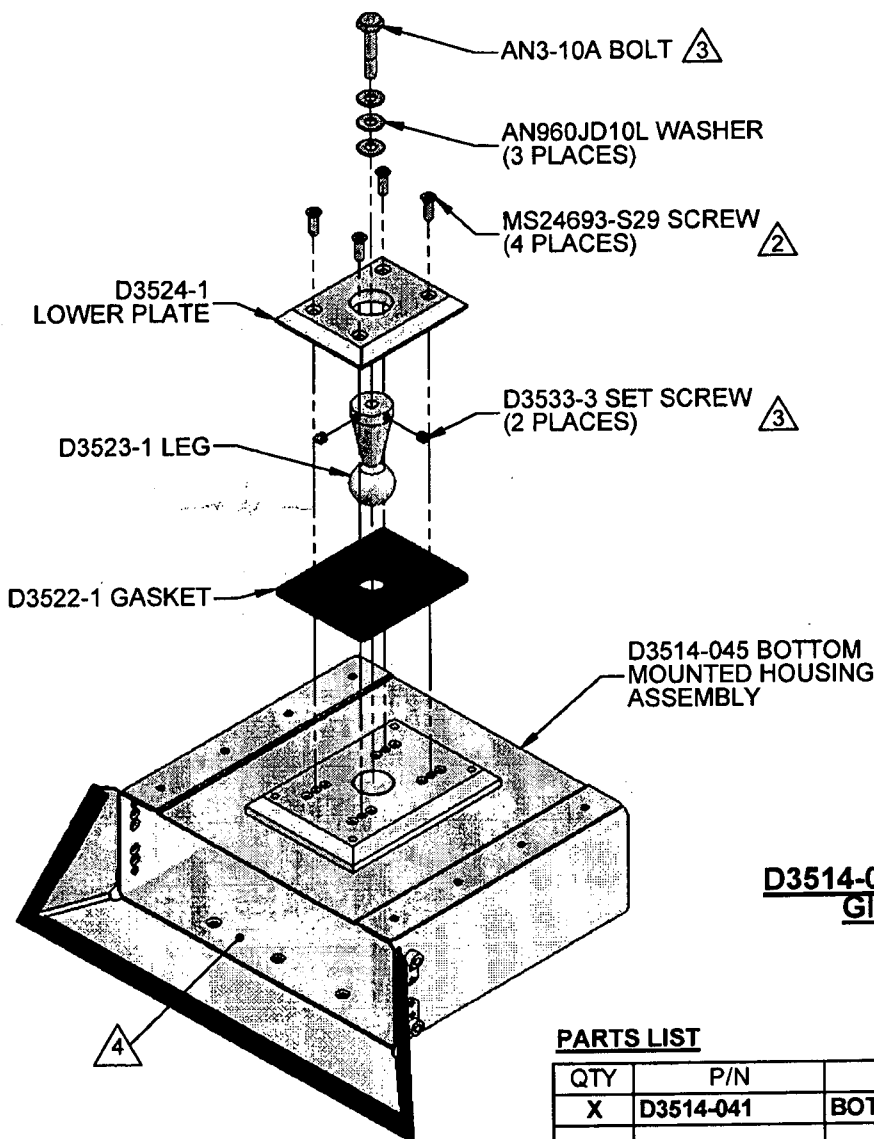
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Shop Packet Print

Page 3



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3514	REV. A SHEET 1 OF 9
DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3
REV A	DATE 07.06.18	DESCRIPTION NEW ISSUE	



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07.08.07

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WORK ORDER
NO. 53021
B/H 09/10/22

**D3514-041 BOTTOM MOUNTED
GIMBAL ASSEMBLY**

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-041	BOTTOM MOUNTED GIMBAL ASSEMBLY
1	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-1	LEG
1	D3524-1	LOWER PLATE
2	D3533-3	SET SCREW
1	AN3-10A	BOLT
3	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

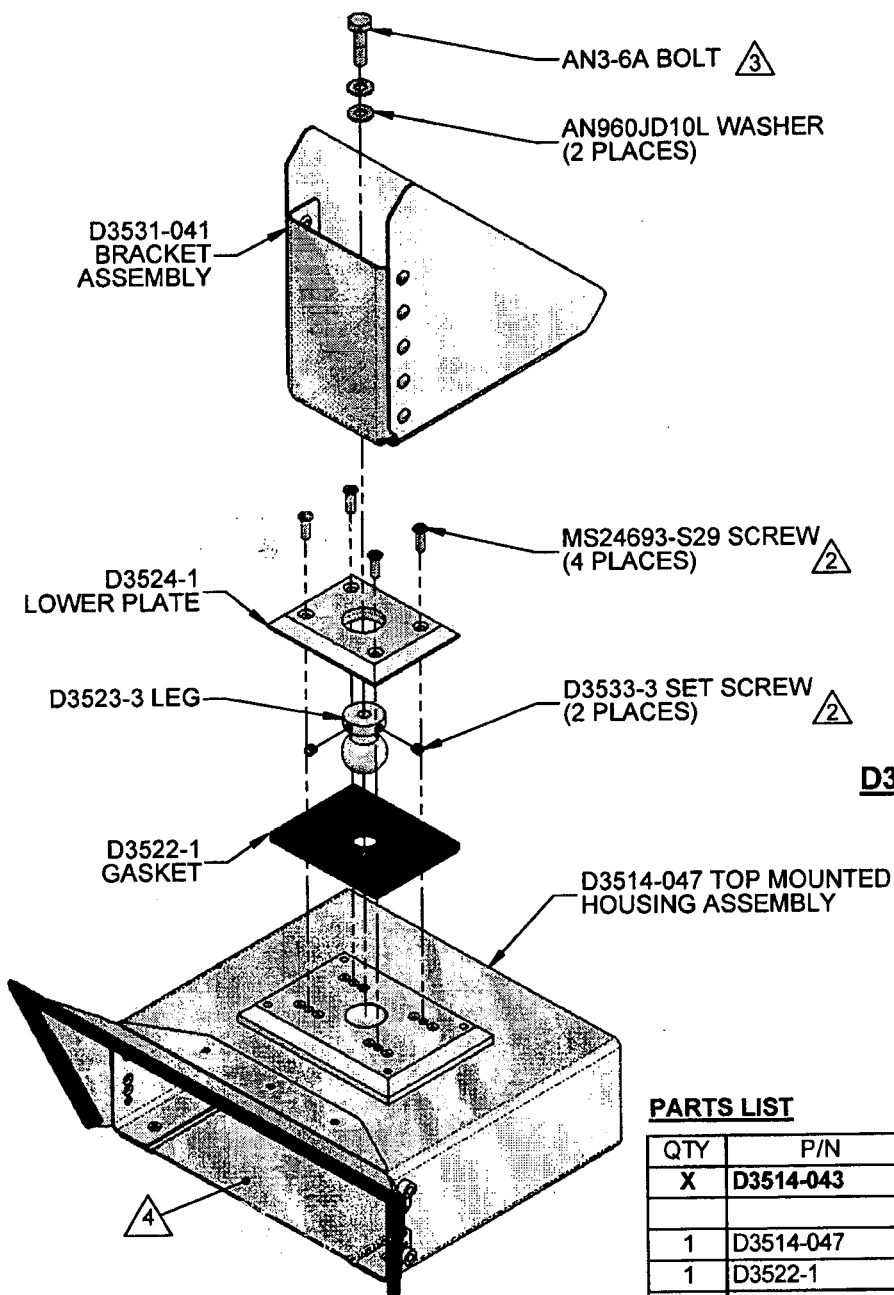
- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TIGHTEN TO SNUG FIT ONLY
- 4) IDENTIFY WITH DART P/N "D3514-041" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3



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WORK ORDER
NO. 53021

**D3514-043 TOP MOUNTED
GIMBAL ASSEMBLY**

PARTS LIST

QTY	P/N	DESCRIPTION
X	D3514-043	TOP MOUNTED GIMBAL ASSEMBLY
1	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3522-1	GASKET
1	D3523-3	LEG
1	D3524-1	LOWER PLATE
1	D3531-041	BRACKET ASSEMBLY
2	D3533-3	SET SCREW
1	AN3-6A	BOLT
2	AN960JD10L	WASHER
4	MS24693-S29	SCREW

NOTE:

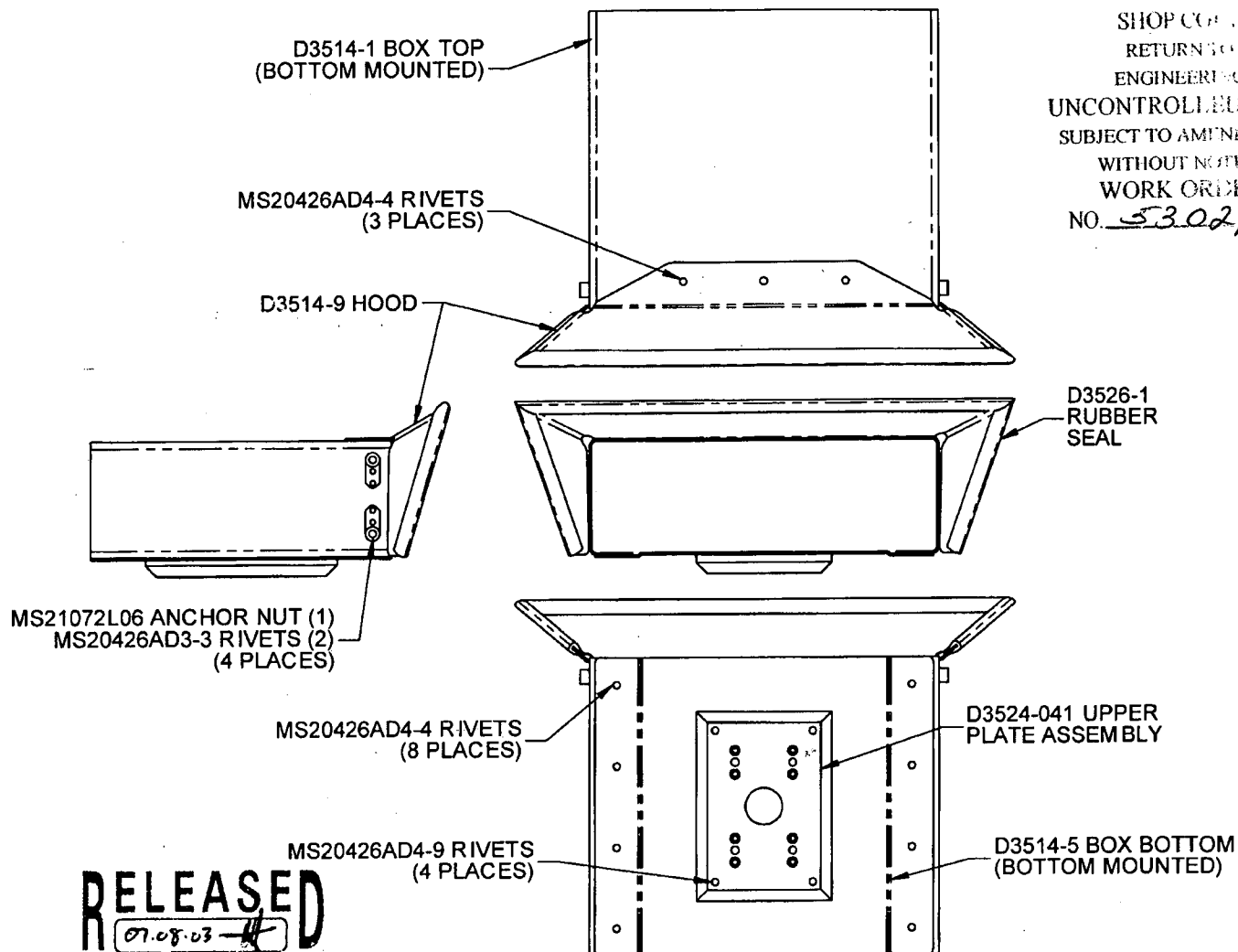
- 1) ASSEMBLE PER DART QSI 003
- 2) TORQUE SCREWS TO 5-6 in-lbs
- 3) TORQUE BOLTS TO 15-25 in-lbs
- 4) IDENTIFY WITH DART P/N "D3514-043" USING A WHITE MARKER ON THE INSIDE OF THE HOUSING ASSEMBLY WHERE INDICATED

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DATE 07.06.18	TITLE GPS RECEIVER HOUSING		SHEET 3 OF 9 SCALE 1:3



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D3514-045 BOTTOM MOUNTED HOUSING ASSEMBLY

NOTES:

- 1) POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

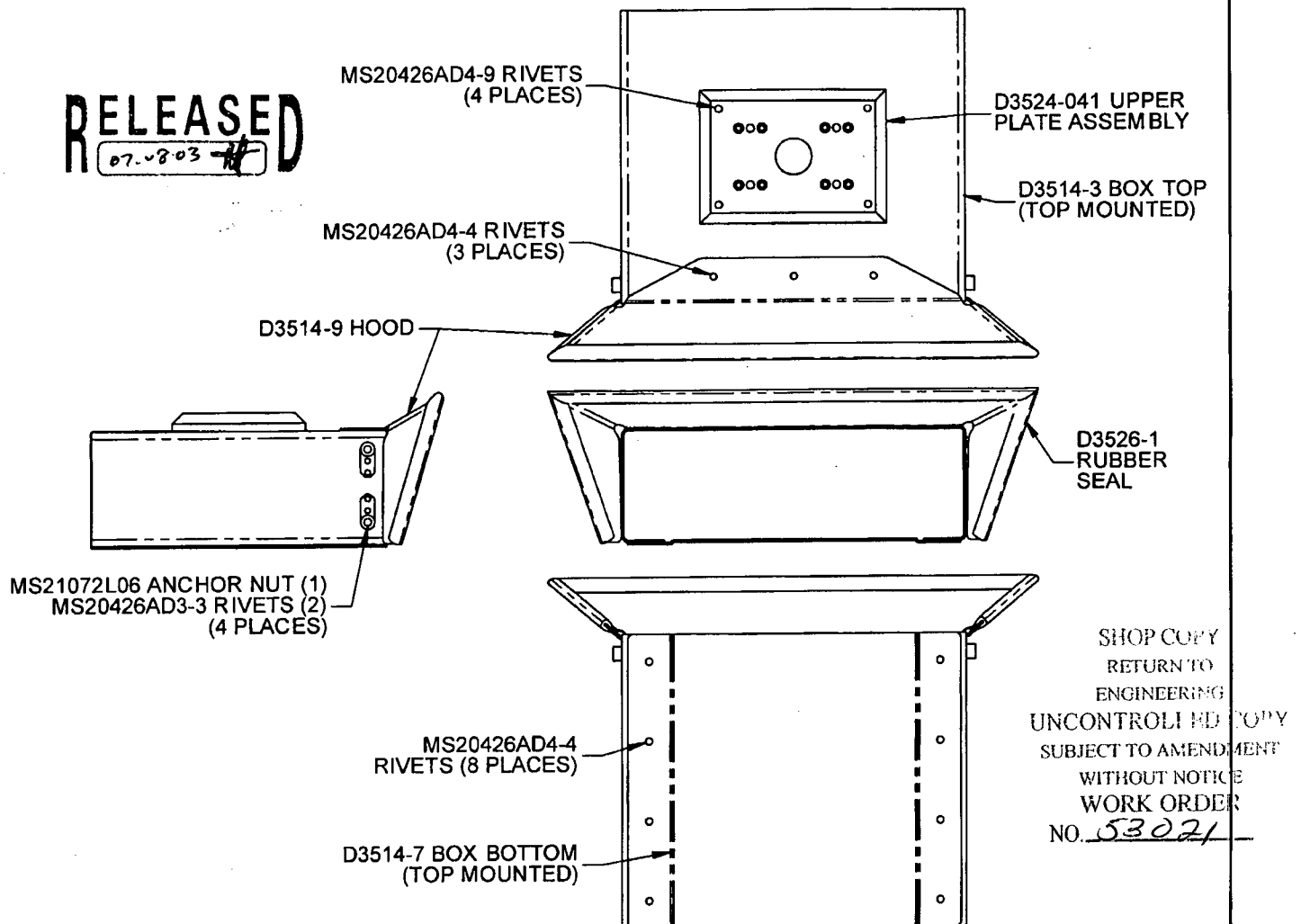
QTY	P/N	DESCRIPTION
X	D3514-045	BOTTOM MOUNTED HOUSING ASSEMBLY
1	D3514-1	BOX TOP (BOTTOM MOUNTED)
1	D3514-5	BOX BOTTOM (BOTTOM MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:3

RELEASED
07.08.03**D3514-047 TOP MOUNTED
HOUSING ASSEMBLY****NOTES:**

- 1) POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3.
- 2) ASSEMBLE PER DART QSI 003

PARTS LIST

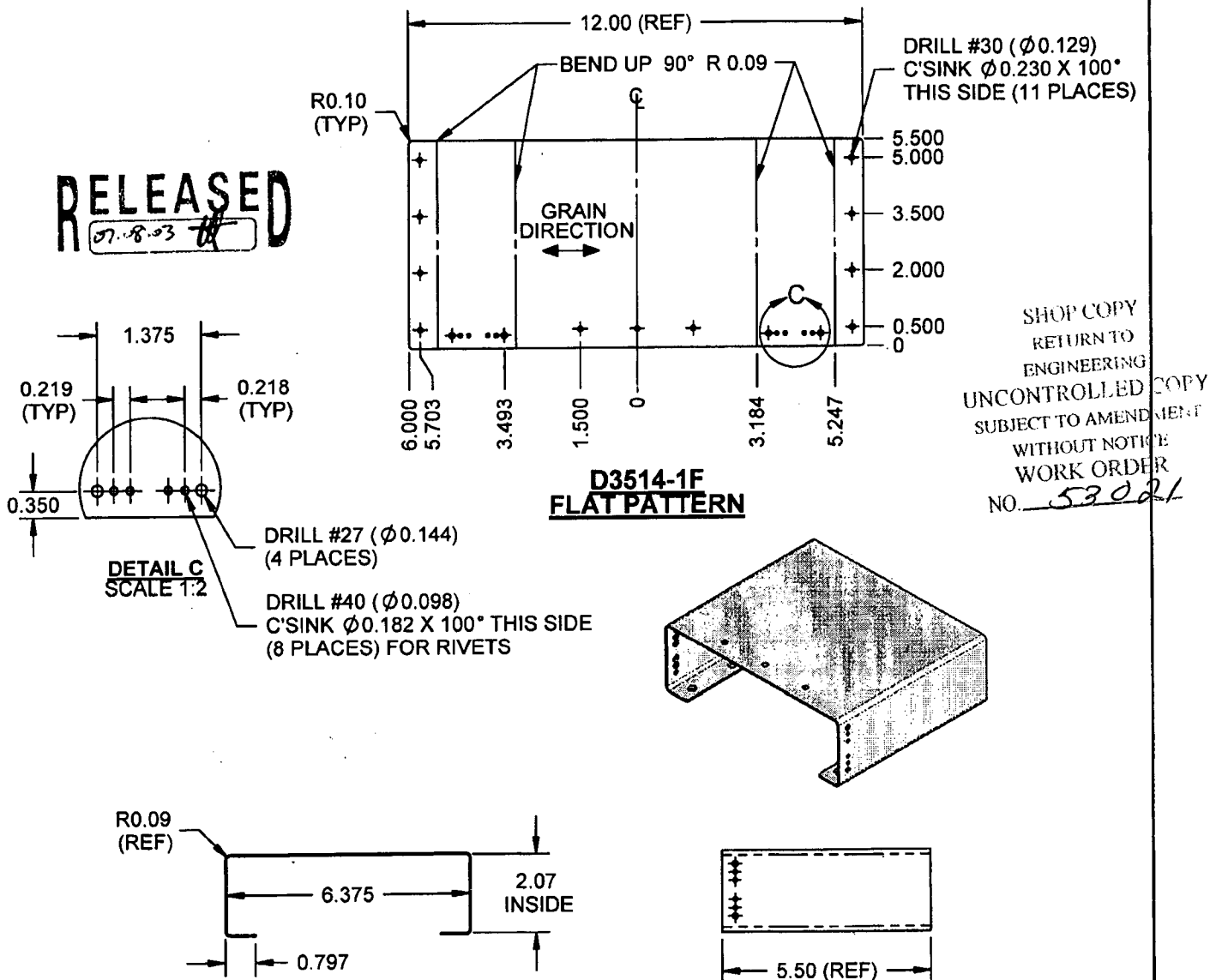
QTY	P/N	DESCRIPTION
X	D3514-047	TOP MOUNTED HOUSING ASSEMBLY
1	D3514-3	BOX TOP (TOP MOUNTED)
1	D3514-7	BOX BOTTOM (TOP MOUNTED)
1	D3514-9	HOOD
1	D3524-041	UPPER PLATE ASSEMBLY
1	D3526-1	RUBBER SEAL
8	MS20426AD3-3	RIVET
11	MS20426AD4-4	RIVET
4	MS20426AD4-9	RIVET
4	MS21072L06	ANCHOR NUT

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DATE 07.06.18	TITLE GPS RECEIVER HOUSING	SCALE 1:4



NOTES:

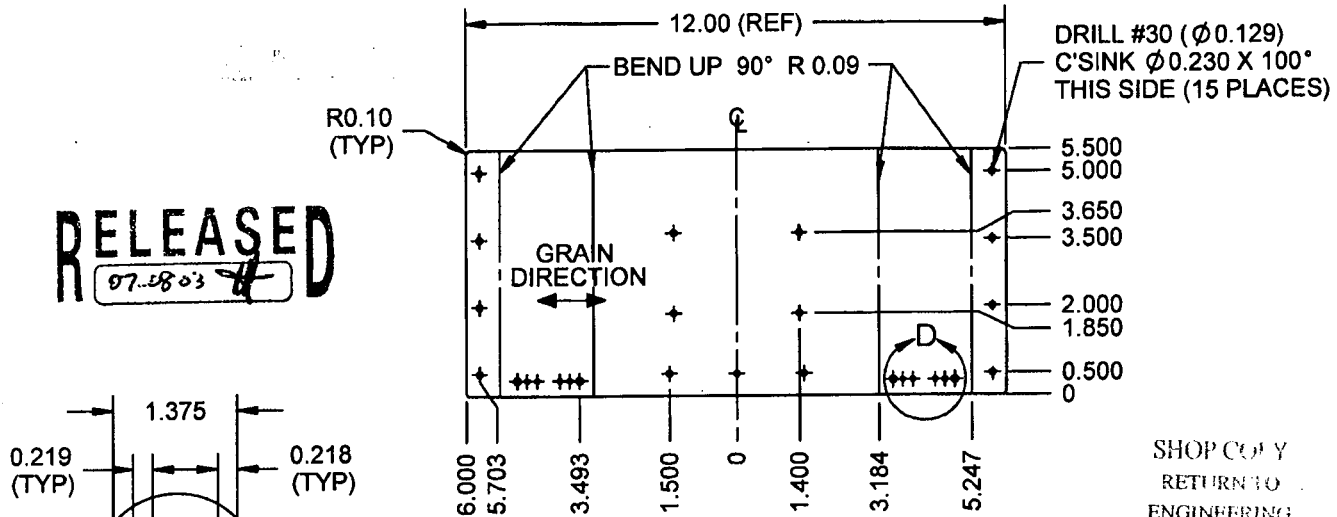
- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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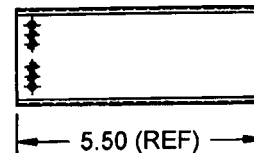
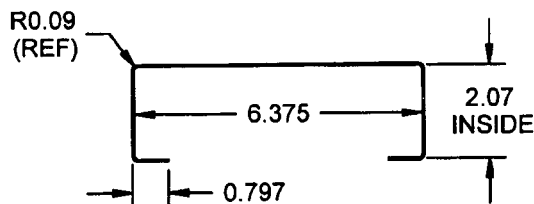
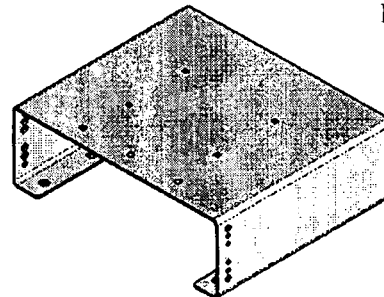
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:4

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**D3514-3 BOX TOP (TOP MOUNTED)****NOTES:**

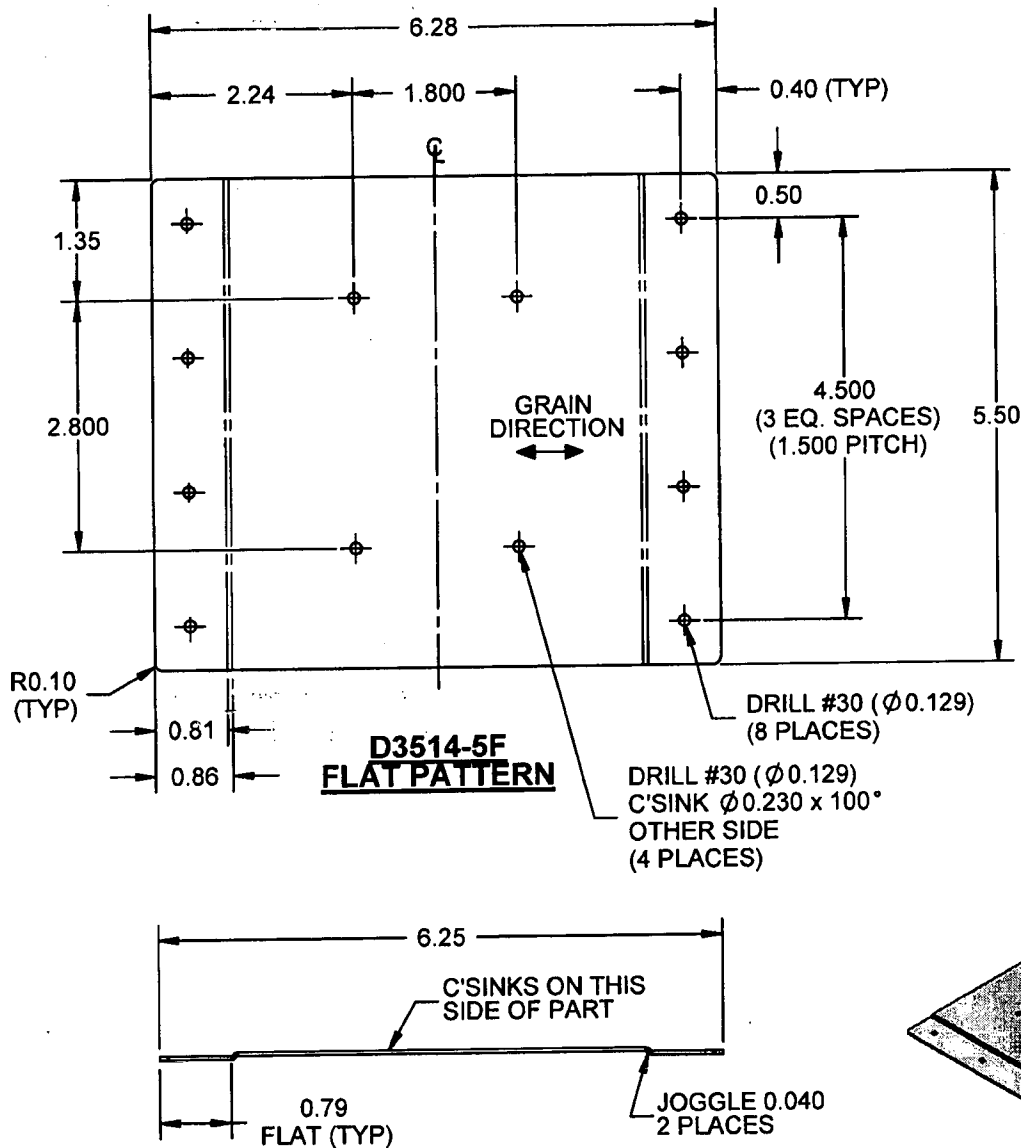
- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINKS ARE ON THE INSIDE OF PART (AFTER BENDING)

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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



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D3514-5 BOX BOTTOM (BOTTOM MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ
- 7) C'SINK ABOVE JOGGLE

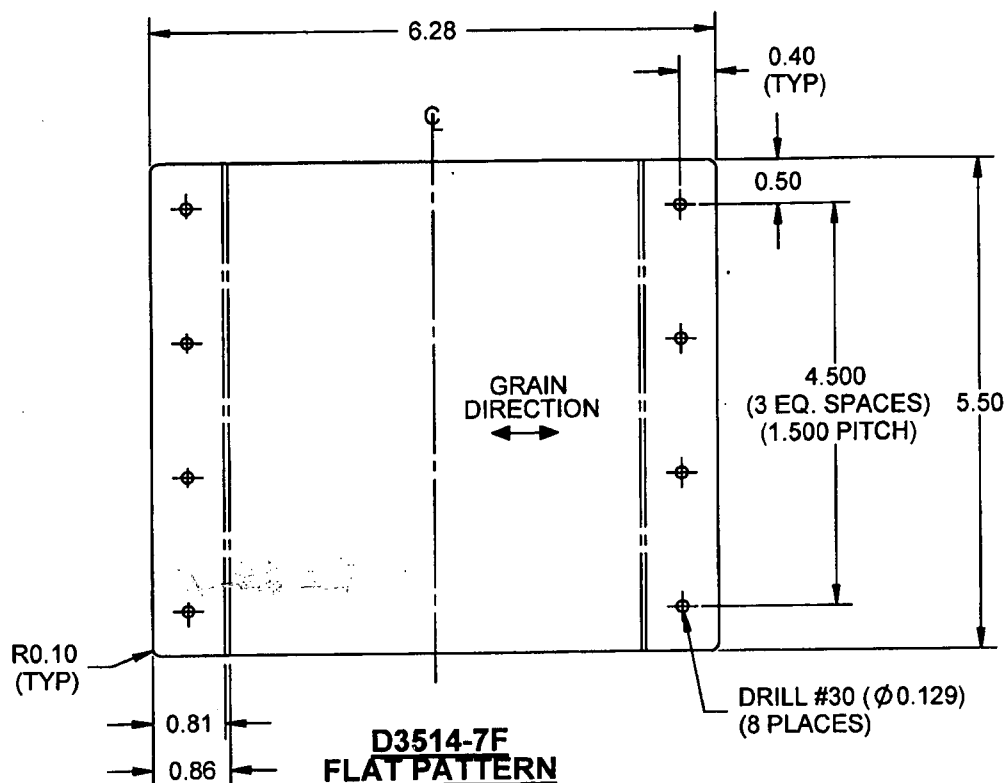
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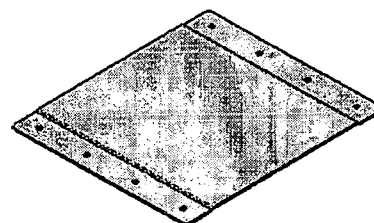
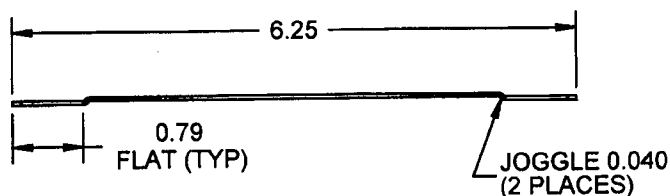
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



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D3514-7 BOX BOTTOM (TOP MOUNTED)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

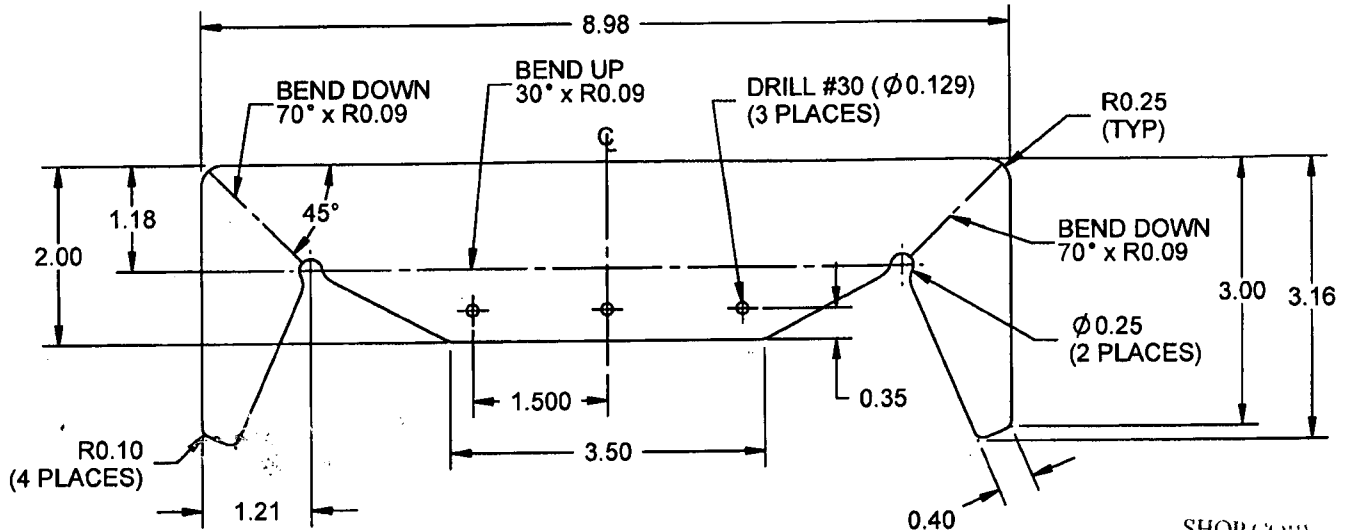
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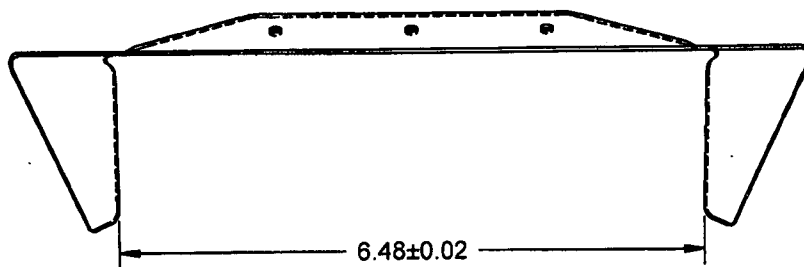
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DATE 07.06.18		TITLE GPS RECEIVER HOUSING	SCALE 1:2



D3514-9F
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FRONT VIEW



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D3514-9 HOOD

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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